

Deriv 64833
 ASAP

Work Order ID 52223



September 21, 2009 9:23:36 AM

Item ID: D3048-1
 Revision ID: A2
 Item Name: Doubler

Accept



Setup Start



Stop



Start Date: 9/21/09 Start Qty: 2.00
 Required Date: 9/22/09 Req'd Qty: 2.00



Cust Item ID:
 Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<div> <div>Draw Nbr</div> <div>Revision Nbr</div> </div> <div> <div>D3048</div> <div>Rev A2</div> </div>									
100	FLOW WATER JET	0.00							
	Waterjet								
	FLOW CNC Waterjet								
	Memo	0.00							
	1-Cut as per Dwg D3048								
	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
	Quality Control								
	Memo	0.00							

B99-21

3

B99-21

2> Sorlos/22

73

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52223

September 21, 2009 9:23:37 AM

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Cust Item ID:

Customer:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form on CNC Brake per Dwg D3048

0.00

0.00

SB 10/11/26

3

PTD

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10 12 15 (3)

150



QC

Quality Control

QC- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/12/15

x3

PH =>

W/O: 52223

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/15	# 100	Step #150 QCS inspection should be changed to QCS chemical coat inspection.	<i>[Signature]</i>	10-12-17			<i>[Signature]</i> 10/12/15

Part No: D3048-1 PAR #: _____ Fault Category: Small Fals NCR: Yes No DQA: [Signature] Date: 10/12/17
 Resolution: Accepted Disposition: Use as is. QA: N/C Closed: [Signature] Date: 10/12/20

NCR: 52223

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/26	130	1 part is out of tolerance of .020 R-C process	<i>[Signature]</i> 10.12.14	Scrap & destroy ACCEPTABLE DEVIATION. 1.68" Dim 1.63 is 1.68"	SB 10/11/26	<i>[Signature]</i> 10/12/14	<i>[Signature]</i> 10.12.14	<i>[Signature]</i> 10/12/14

NOTE: Date & initial all entries

Work Order ID 52223

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Start Qty: 2.00



Cust Item ID:

Required Date: 9/22/09

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 139

0.00



Packaging

Memo

0.00

Packaging

10/12/16 SP (30)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/17

10-12-16

Picklist Print

September 21, 2009 9:23:36 AM

Page 1

Work Order ID: 52223

Parent Item: D3048-1RevA2

Parent Item Name: Doubler

Comments:

Start Date: 9/21/09

Required Date: 9/22/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	107.1442	7.2806	10.9229		



2024-T3 .063 sheet

B9-9-21

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	107.1442242	
102942	1.5	
105916	3.69	
106223	1.47	
109463	3.22947368	
110980	5.4854	
111787	89.7693505	
19059	2	

111787

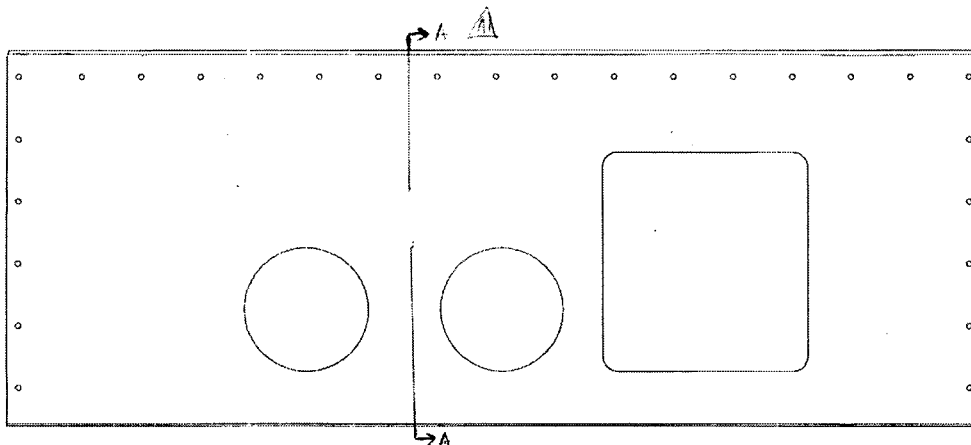
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

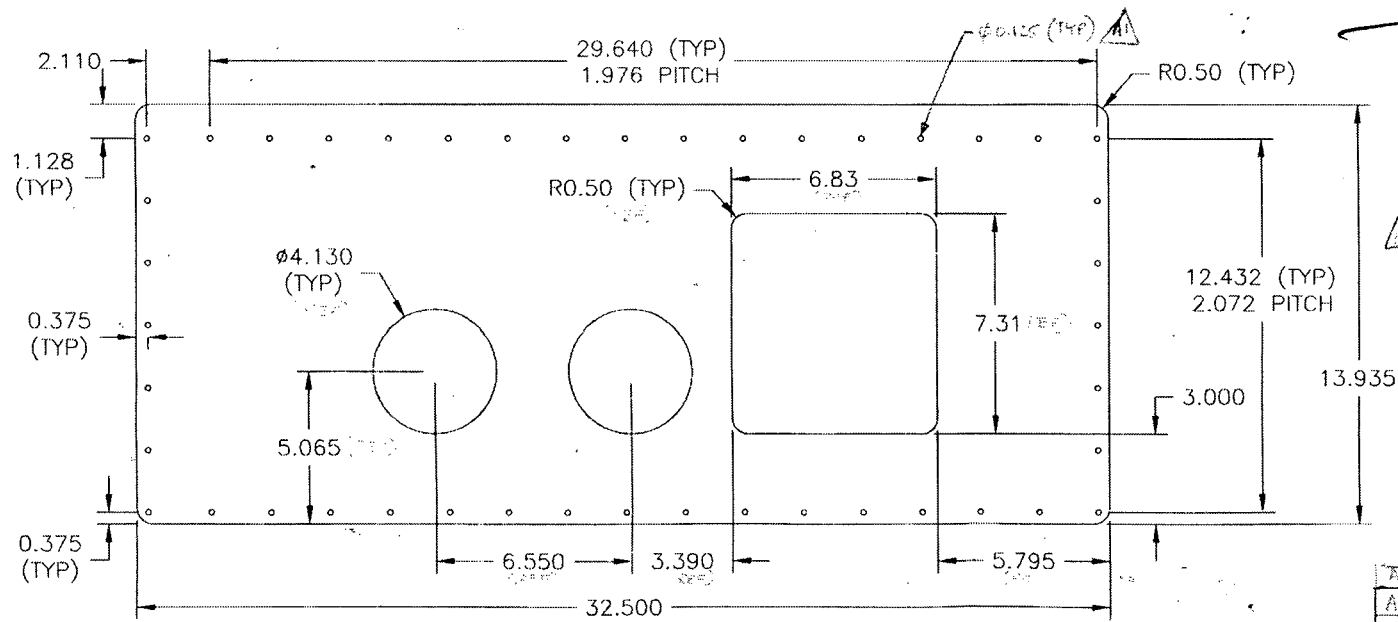
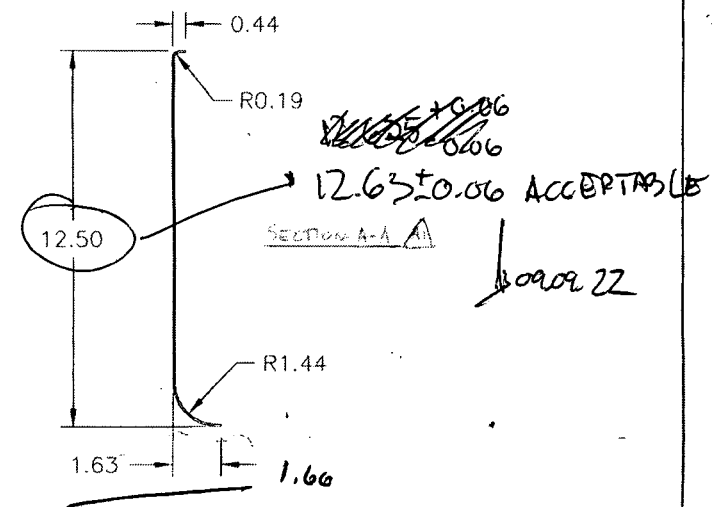
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3048-1



D3048-1 FLAT PATTERN

MATERIAL: 2024-T3 (Q0-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

AS NOTED, ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE NOTED

W/052223



AI	02 11 20	CORRECT DIMS EXPLD
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY RT	DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3048
DATE	01.09.25	TITLE DOUBLER
		REV. A SHEET 1 OF 1 SCALE 1:4

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